

Work Order ID 50890

July 23, 2009 2:13:48 PM



Page 1

Item ID: D3516-041

Accept



Setup Start



Revision ID: C

Item Name: Basket Base Assembly (A119)

Stop



Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

W

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3516

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut rib D3516-1 as per dwg D3516 12-Cut rib D3516-3 as per dwg D3516 13-Cut rib D3516-5 as per dwg D3516 14-Cut rib D3516-7 as per dwg D3516 15-Cut rib D3516-15 as per dwg D3516 16-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

\$

SAD 09-07-21

(Qty 1)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3516

PD 09-07-21

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

lp 09-07-28

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Item ID: D3516-041

Accept

Revision ID: C

Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09 Start Qty: 1.00

Required Date: 8/07/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 112-Cut expanded metal for base ends as per dwg D3516 113-Weld expanded metal to base as per dwg D3516

PD 09.07.29

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

lpl 09-07-30

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Item ID: D3516-041

Accept

Revision ID: C

Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09 Start Qty: 1.00

Required Date: 8/07/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

1ST COAT: (START TIME: 1:45pm) OVEN
TEMPERATURE: 2:15pm FINISH TIME: 400°F
2:30pm ***** 2nd coat if
necessary ***** 2ND COAT: (START TIME:
3:00pm) OVEN TEMPERATURE: 400°F

X112148

09-07-30

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

BR 09-08-14

0.

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Item ID: D3516-041

Accept



Setup Start



Revision ID: C

Item Name: Basket Base Assembly (A119)

Stop



Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

88850888

9/8/5

Ⓚ

SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/08/19

Quality Control

MF 09-08-19

Picklist Print

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Work Order ID: 50890

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC

Manufactured

No

100

Each

11.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

48443

9

50024

6

Main Warehouse

WA

-4

48443

-4

2 PD 09.07.27

D2327-3RevD

Manufactured

No

100

Each

64.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Premier

Mezz

70

44274

61

44365

9

Main Warehouse

ST

-6

44274

-6

2 PD 09.07.24

Picklist Print

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Work Order ID: 50890

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)



Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	15.0000	2.0000			
												
Mounting Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

46086

2

48428

21

2 PD 09-07-29

Main Warehouse

WA

-8

48428

-8

D3166-1RevA1

Manufactured

No

100

Each

7.0000

4.0000



Basket Hoop



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

7

50172

7

4 CP 09-07-23

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 50890

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)


Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	16.0000	2.0000			
												
Shim												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 20

46767 1


47074 7

50023 12

Main Warehouse

WA -4

47074 -4

D3516-11RevC		Manufactured	No			100	Each	15.0000	6.0000			
												
Clevis												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

45714 15

PD 09.01.27

6 PD 09.01.27

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Work Order ID: 50890

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3516-13RevC

Manufactured

No

100

Each

73.0000

4.0000



Clevis

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

45564

34

45565

39

4

PD 09.07.27

D3725-1RevA

Manufactured

No

100

Each

3.0000

2.0000



Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

45575

3

2

PD 09.07.24

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Picklist Print

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Page 5

Work Order ID: 50890

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)

Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	482.5287	60.0000			
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

482.5287065

108152 90
110134 6.7
110292 14.4
110629 14.41
110861 21.18
110992 0.58
111444 17.79
111630 27.15
111956 6.335517
112147 283.983189

60.000

M304TS0.750W.065

Purchased

No

140 f

506.9338 53.3158

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

506.9338137

111148 0.484
111432 0.44
111885 1.5682
112051 30.7574737
112263 473.68414

30.00
23.3158

SAD 09-07-27 - (Qty)

SAD 09-07-24

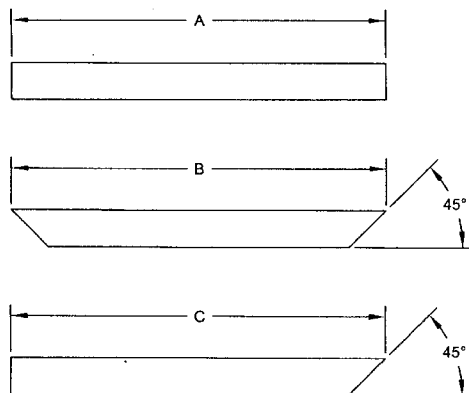
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Shop Packet Print

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PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	---	102.00	---	RIB
D3516-3	2	---	---	2.70	RIB
D3516-5	8	26.75	---	---	RIB
D3516-7	3	45.50	---	---	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	---	---	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

1) MATERIAL:

FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)

MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)

2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 75 lbs

8) WELDING: PER DART QSI 004

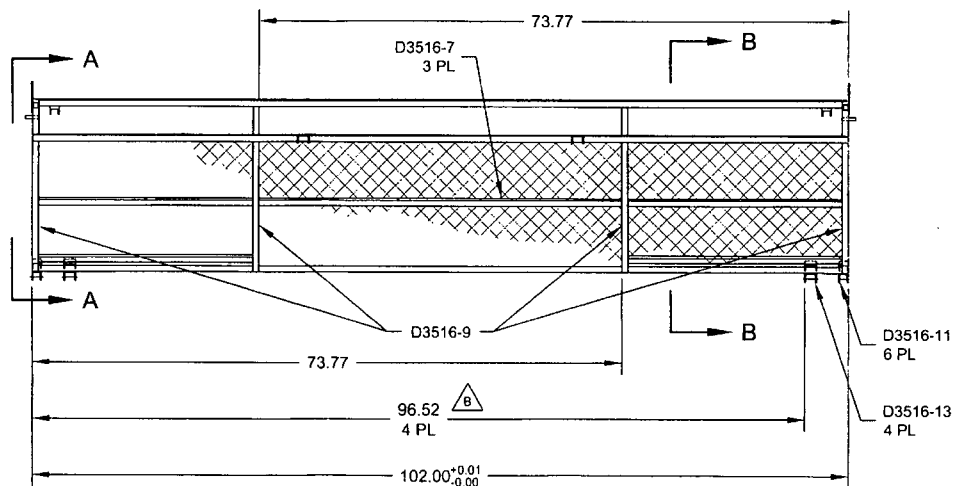
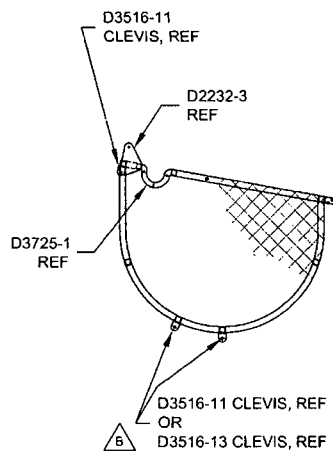
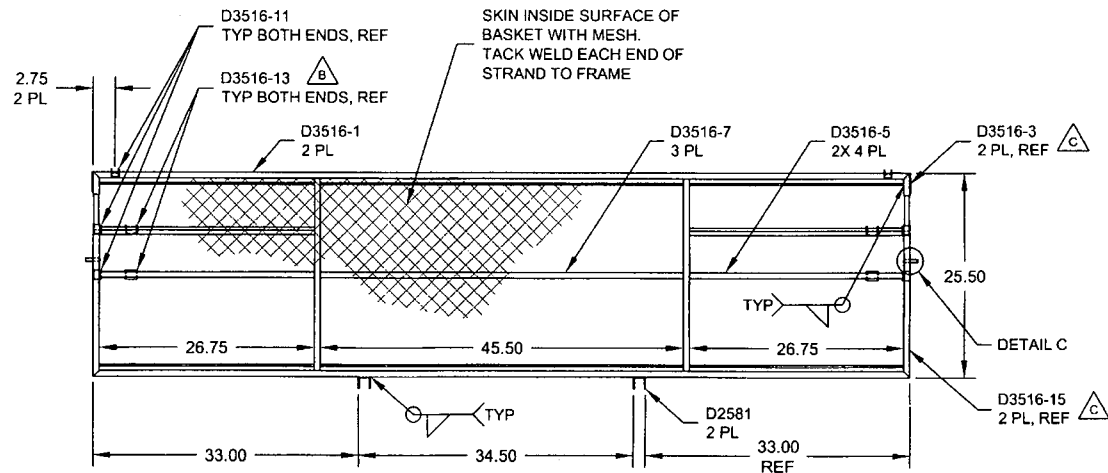
C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D115-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3516 REV. C
SHEET 1 OF 4

TITLE BASKET BASE ASSEMBLY SCALE NTS

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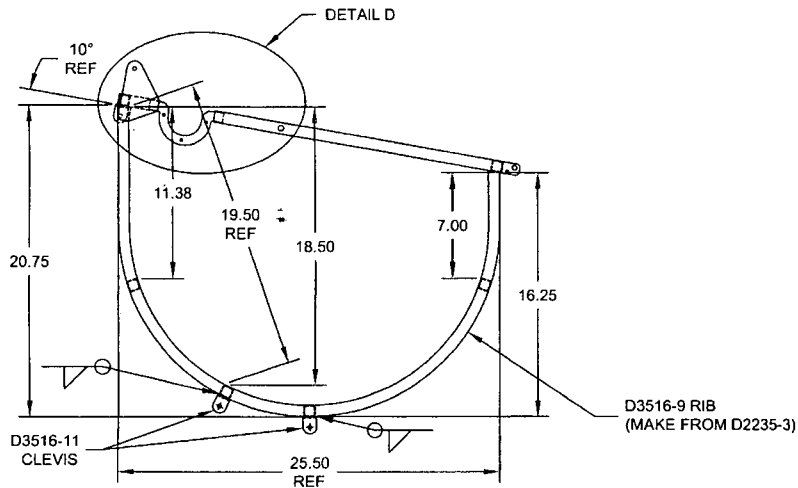


D3516-041 BASKET BASE ASSEMBLY

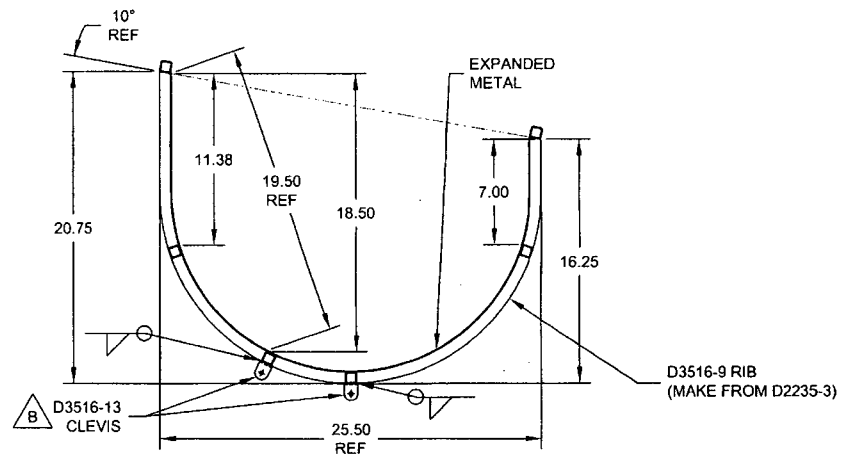
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3516 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119) NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD

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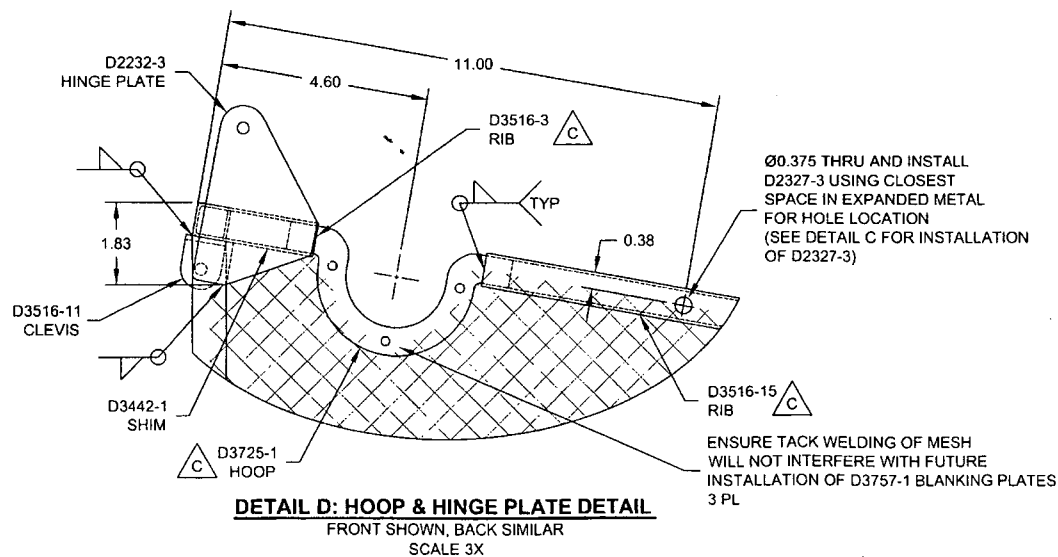
50890
108-03-17-17



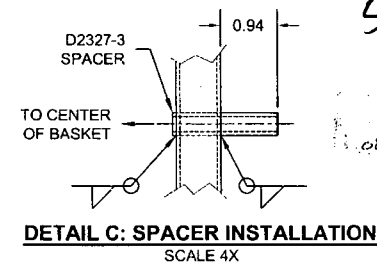
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL

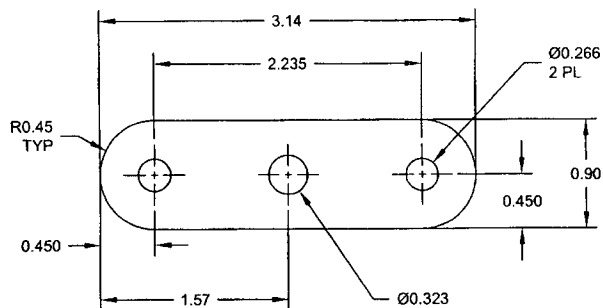


DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X

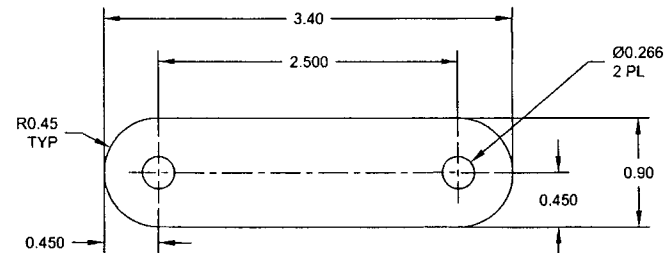


DETAIL C: SPACER INSTALLATION
SCALE 4X

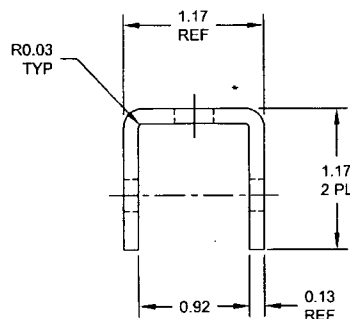
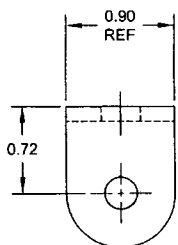
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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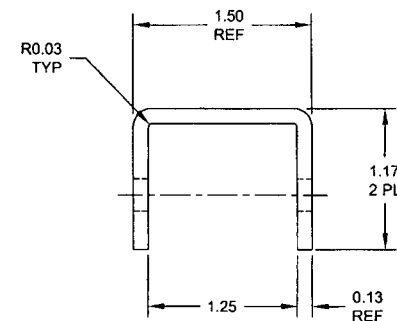
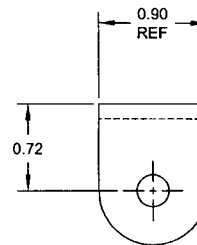
1 D3516-11F CLEVIS FLAT PATTERN



1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)

D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119)	NT
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